

# Work Order ID 89834

\*89834\*

Page 1

September-11-12 10:19:22 AM

Item ID: D3580-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Joggle Bracket  
 Start Date: 9/11/12 Start Qty: 60.00 \*60\* Cust Item ID:  
 Required Date: 9/28/12 Req'd Qty: 60.00 \*60\* Customer:  
 Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3580	Rev B								

100	FLOW WATER JET	0.00				75	0		Jm 12-9-12
*100*									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3580								
304, 050	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				75	0		Jm 12-9-12
*110*									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00				75			
*120*									
QC	Memo	0.00	Smb			cont			
Quality Control			12-9-12						

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**\*89834\***

Page 2

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 Item Name: Joggle Bracket  
 Start Date: 9/11/12 Start Qty: 60.00 **\*60\*** Cust Item ID:  
 Required Date: 9/28/12 Req'd Qty: 60.00 **\*60\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>	Small Fab					75			SB 12/09/19
Small Fab	Memo	0.00							
Small Fab	Bend as per dwg D3580 using 1/8" offset die								
140		0.00							
<b>*140*</b>	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00	SMB 12-9-19	171471		75			QWNT
Quality Control									
150		0.00							
<b>*150*</b>	Identify as per dwg & Stock Location: 38								
Packaging	Memo	0.00	Autre			45			12/9/2019
Packaging	Bach		AWS						

**Work Order ID 89834****\*89834\***

Page 3

September-11-12 10:19:22 AM

Item ID: D3580-1      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
Revision ID:      Stop **\*NS2\***  
Item Name: Joggle Bracket  
Start Date: 9/11/12      Start Qty: 60.00      **\*60\***      Cust Item ID:  
Required Date: 9/28/12      Req'd Qty: 60.00      **\*60\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

12/9/24 JF  
MF  
12-09-24

# Picklist Print

September-11-12 10:19:22 AM

Page 1

Work Order ID: 89834

Parent Item: D3580-1

Parent Item Name: Joggle Bracket

Start Date: 9/11/12

Required Date: 9/28/12

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP Rev :A New Issue 07.06.25 EC  
IPP Rev:B Removed Powder Coat 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA 304/316 .050 Sheet		Purchased	No			100	sf	272.7349	0.01	<del>0.6315789</del> 0.75			Jm 12-9-12



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	272.734947	
120604	5.13421	
121626	1.65	
121660	27.000737	
122325	238.95	

120604

89834

☒ First Article ☐ Prototype

Measured by:	Jm	Audited by:	SmB	Prototype Approval:	N/A
Date:	12-9-12	Date:	12-9-12	Date:	N/A

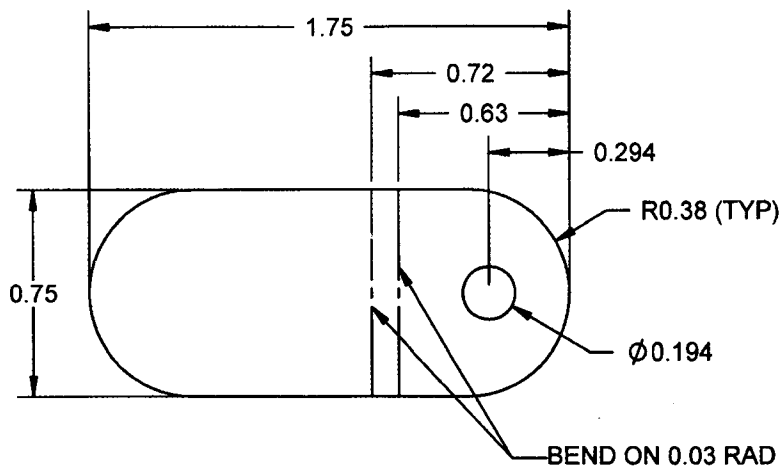
by	Appr
	



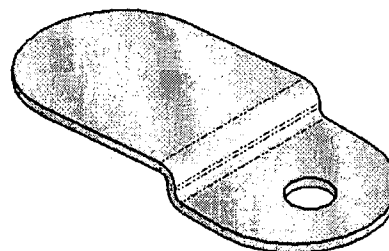
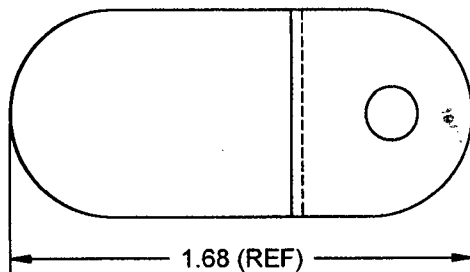
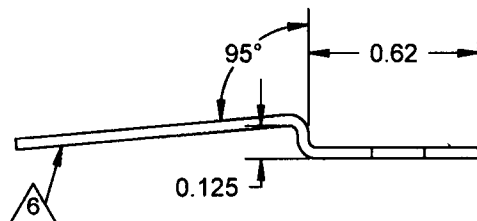
DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3580	REV. B SHEET 1 OF 1
DATE 07.07.09		TITLE JOGGLE BRACKET	SCALE 3:2
REV	DATE	DESCRIPTION	
A	07.05.15	NEW ISSUE	
B	07.07.09	REMOVE POWDER COAT	

RELEASED

07.07.09 *[Signature]*



**D3580-1F FLAT PATTERN**



*4089834*

**D3580-1 JOGGLE BRACKET**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)  
PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3580-1" USING FINE POINT PERMANENT INK MARKER  
ON THE UNDERSIDE OF THE PART AS INDICATED

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